



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5805-041

Job Sheet 207469



Part No: D5805-041

Job Qty: 1 pcs

Part Name: Attachment Hoop



Part Weight: 0 lbs

Job Created: 2/26/20

Due Date: 4/3/20

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Jennifer Renwick

Description:

Note: URF 20-522 DWG D5805 REV.A IPP REV:A NEW ISSUE 20.01.15 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	4/3/20		0.00	1.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 8	1 pcs	4/3/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	4/3/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 66		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S268283



Part: D5805-041

Job No: 207469

Serial No/Batch: S268283

Revision: REV.A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/01/20

Plex 3/11/20 3:54 PM Dart.Renwick.Jennifer

				QC 5 - 9	
				QC 5 - 50	12
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
130 Packaging 3-1 - Stock - B4B	1 pcs	4/3/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	12
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	1 pcs	4/3/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	986 APR 02 2020

Part Op 100 - 1- Fabricate as per D5805-041 dwg 2- Weld per dwg. APR 413076 Batch: 159072 USE DT10689***
 Descriptions: 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: W/HOP
 140 - QC21- Final Inspection - Work Order Release

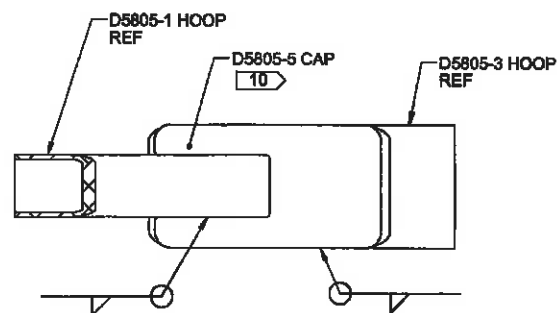
Job BOM

Part / Item	Component Name	Quantity	Operation	Container	
D5770-9	Bushing	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	52624625	259373
D5805-1	Hoop	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5261900	
D5805-3	Hoop	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5264657	5261469
D5805-5	Cap	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5261675	
D5805-7	Stud	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5261615	

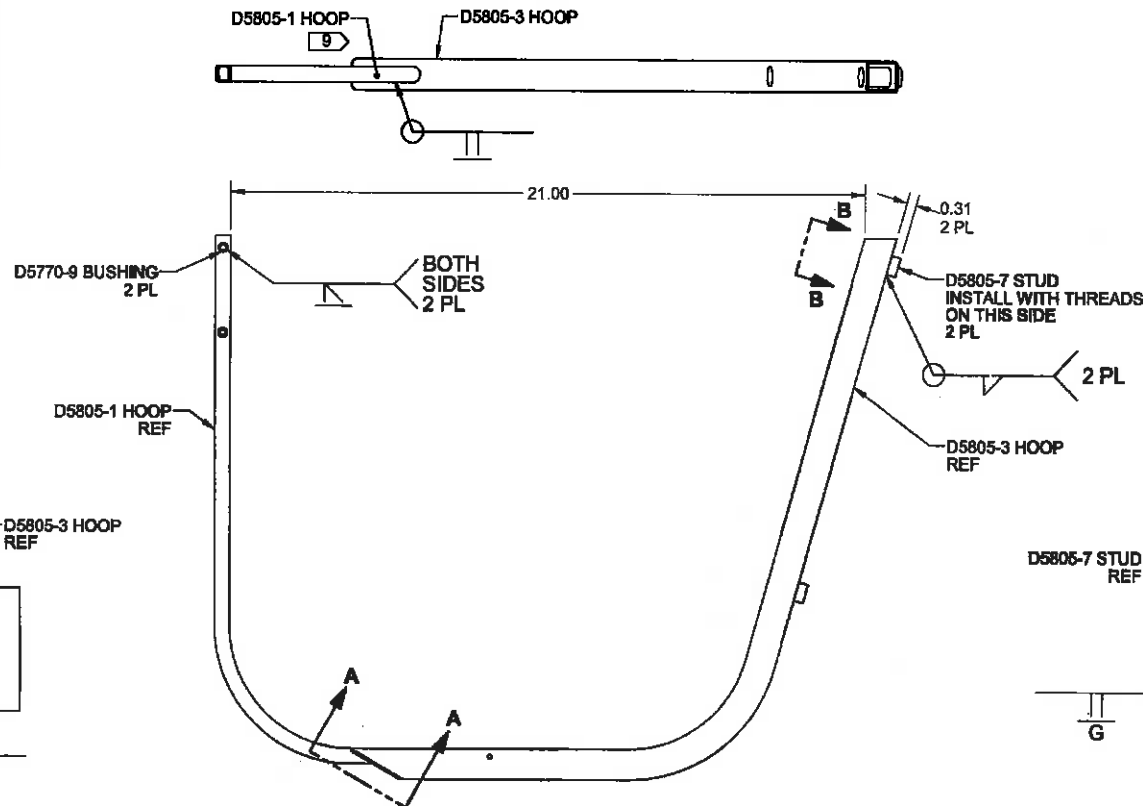
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab -- Welded Assy-1	D5770-9	2	12	0
	D5805-1	1	4	0
	D5805-3	1	4	0
	D5805-5	1	4	0
	D5805-7	2	24	0
Part Specifications				
Specifications could not be found.				

Plex 3/11/20 3:54 PM Dart.Renwick.Jennifer

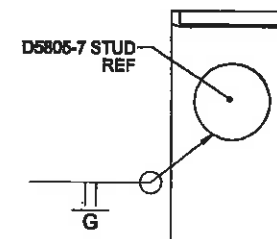
QTY -041	P/N	DESCRIPTION
X	D5805-041	ATTACHMENT HOOP
2	D5770-9	BUSHING
1	D5805-1	HOOP
1	D5805-3	HOOP
1	D5805-5	CAP
2	D5805-7	STUD



SECTION A-A
SCALE 4X



D5805-041 ATTACHMENT HOOP
(DERIVED FROM AERO DESIGN P/N 76423-01)



VIEW B-B
SCALE 4X, 2 PL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207469

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 7) WEIGHT: 2.42 lbs
 8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.
 9) GRIND END OF D5805-1 HOOP TO FIT SLOT OF D5805-3 HOOP
 10) GRIND SLOT OF D5805-5 CAP TO FIT D5805-1 HOOP

RELEASED

2020 FEB 18 *NP*
ECN 2020 - 521

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

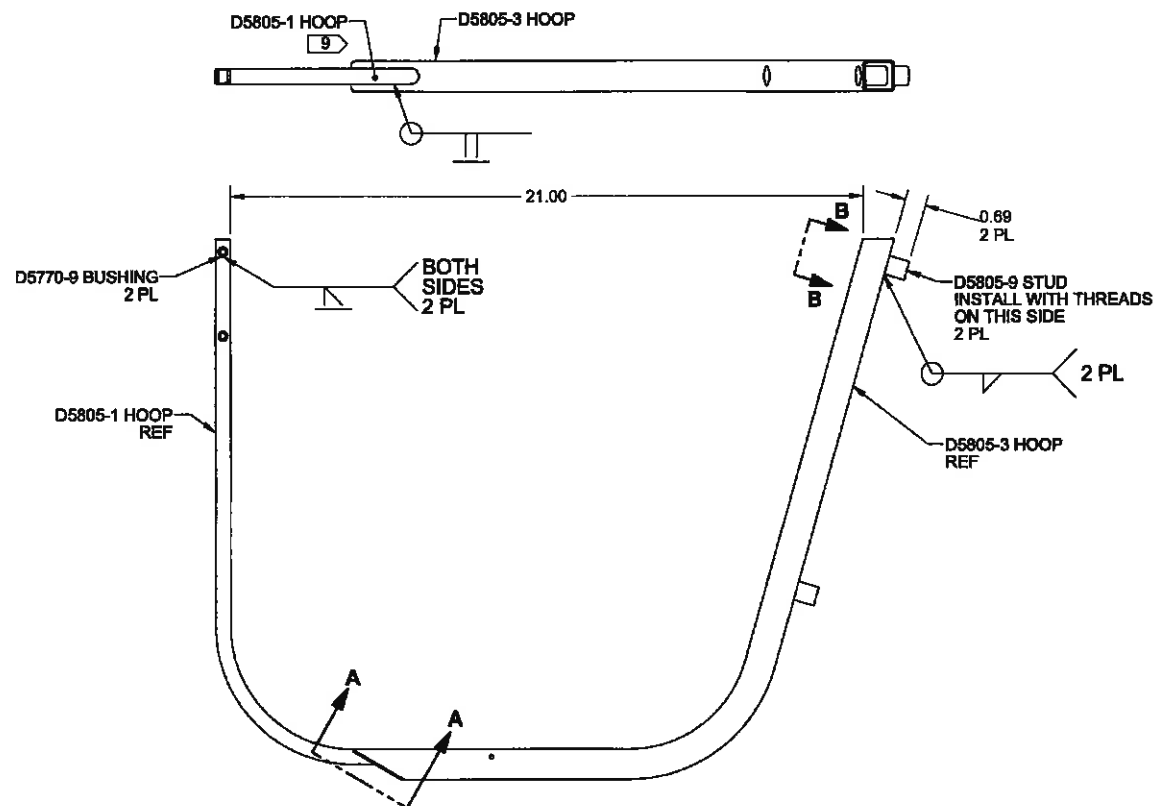
REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	ZF	20.01.13
DESIGN	ZF		
DRAWN	ZF		
CHECKED	KPT		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5805**
TITLE **ATTACHMENT HOOP**
REV. A
SHEET 1 OF 6
SCALE
NTS

COPYRIGHT © 2020 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

QTY -043	P/N	DESCRIPTION
X	D5805-043	ATTACHMENT HOOP
2	D5770-9	BUSHING
1	D5805-1	HOOP
1	D5805-3	HOOP
1	D5805-5	CAP
2	D5805-9	STUD



D5805-043 ATTACHMENT HOOP
(DERIVED FROM AERO DESIGN P/N 78423-07)

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

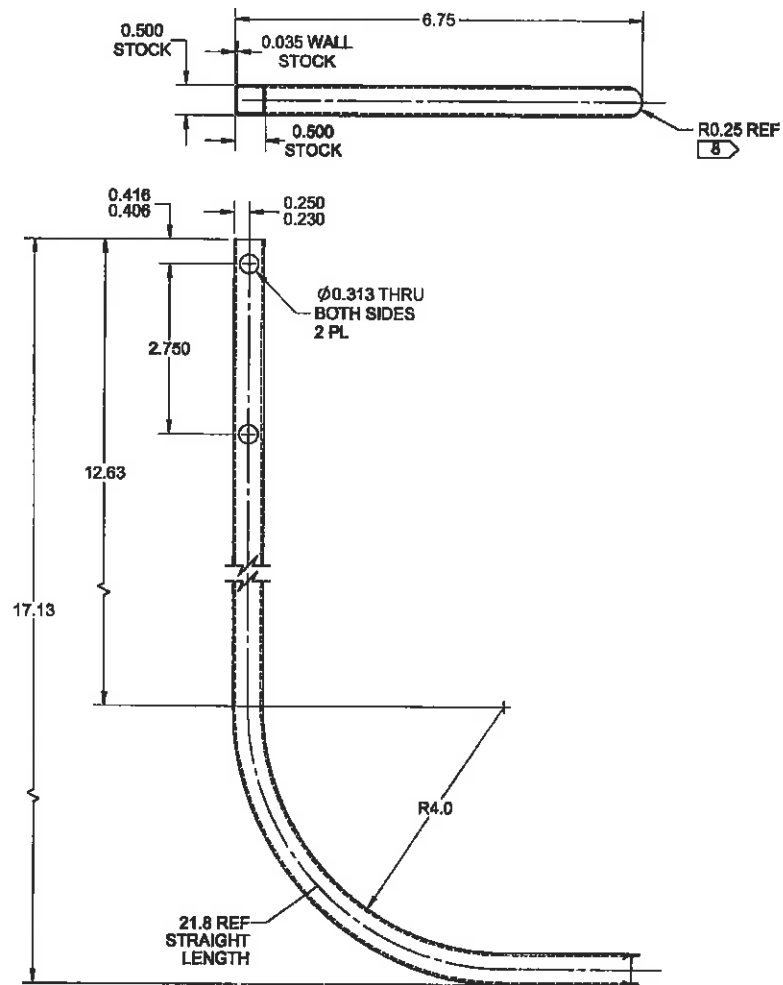
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: 2.49 lbs
- 8) WELD PER DART QSI 004. GRIND WELDS FLUSH IF REQUIRED.
- 9) GRIND END OF D5805-1 HOOP TO FIT SLOT OF D5805-3 HOOP
- 10) GRIND SLOT OF D5805-5 CAP TO FIT D5805-1 HOOP

RELEASED
2020 FEB 18 *ND*

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5805 TITLE ATTACHMENT HOOP <small>COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS APPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. A
DRAWN	ZF		SHEET 2 OF 6
CHECKED	KPT		SCALE
MFG. APPR.	DD		NTS
APPROVED	NO		
DE APPR.	CP <i>CP</i>		
DATE	20.01.13		



D5805-1 HOOP

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1/2 X 0.035 WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF DART SPEC M4130N-TS0.500W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.37 lbs
- 8) GRIND END TO FIT SLOT OF D5805-3 HOOP AT ASSEMBLY

RELEASED
2020 FEB 18 MD

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	REV. A
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	SHEET 3 OF 8
MFG. APPR.	DD	D5805	SCALE
APPROVED	NO	TITLE	NTS
DE APPR.	CP	ATTACHMENT HOOP	
DATE	20.01.13	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

8

7

6

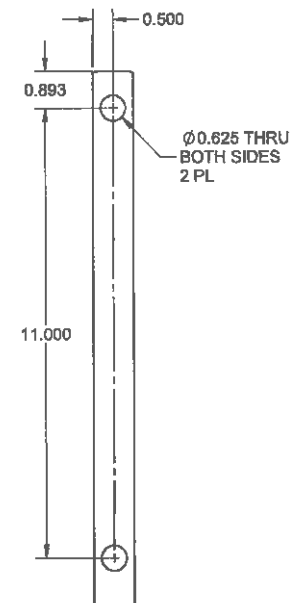
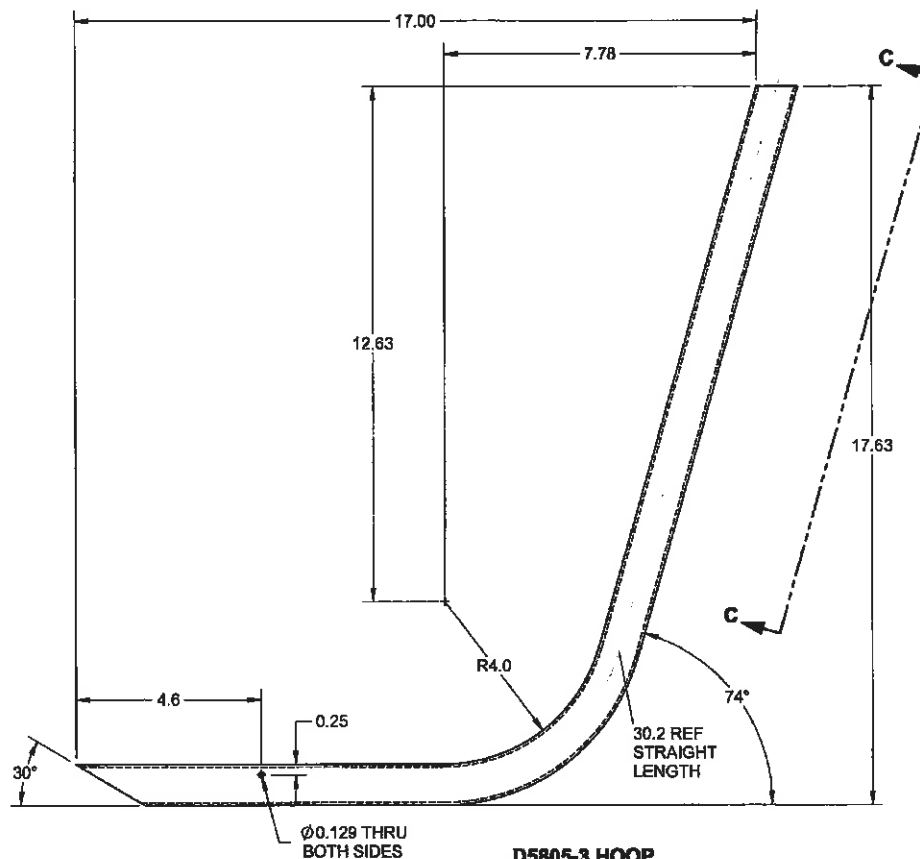
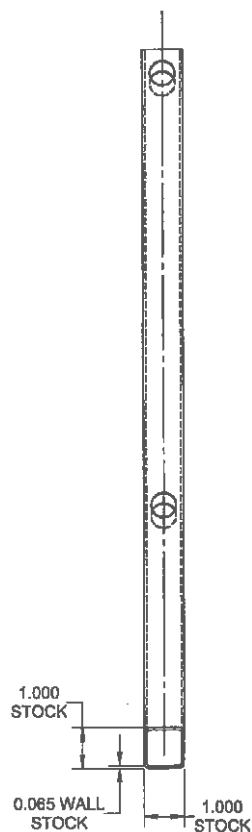
5

4

3

2

1



VIEW C-C

D5805-3 HOOP

NOTES:

- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1 X 0.065 WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF DART SPEC M4130N-TS1.000W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.84 lbs
- 8) GRIND SLOT TO FIT D5805-1 HOOP AT ASSEMBLY.

RELEASED
2020 FEB 18 NO

APPROVED

DESIGN ZF
DRAWN ZF
CHECKED KPT
MFG. APPR. DD
APPROVED NO
DE APPR. CP
DATE 20.01.13

UNDER REVIEW

URF 2020-522 20.02.14 (NO)

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5805

TITLE
ATTACHMENT HOOP

REV. A
SHEET 4 OF 6
SCALE
NTS

COPYRIGHT © 2020 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS
NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

8

7

6

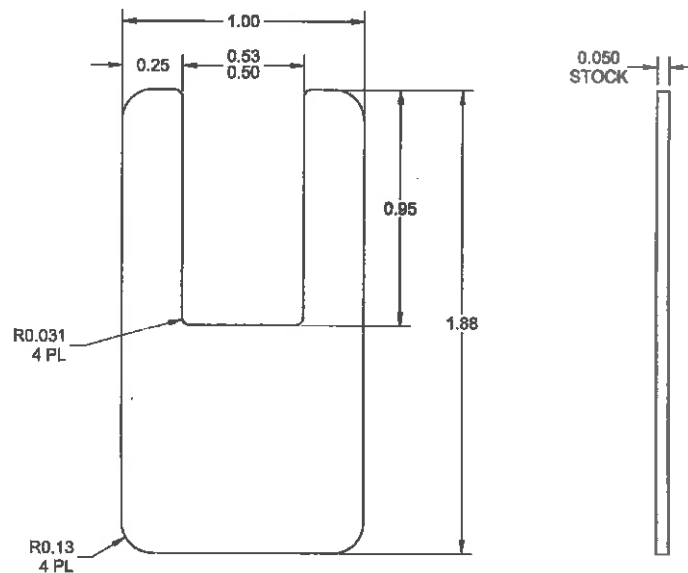
5

4

3

2

1



D5805-5 CAP
(DERIVED FROM AERO DESIGN P/N 76423-04)

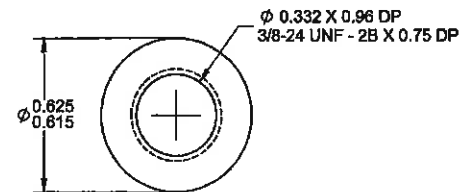
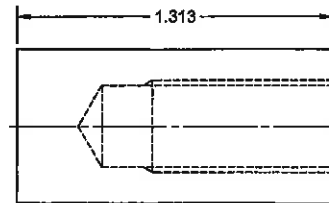
UNDER REVIEW
URF 2020-522 20.02.14 (NO)

- NOTES:**
- 1) MATERIAL: AISI 1010/1025 STEEL SHEET, COLD ROLLED, #18 GA (0.050 THICK)
PER ASTM A36/A368/A1008 OR CSA G40-21 38W/44W/50W/60W/70W
REF DART SPEC M1010-S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

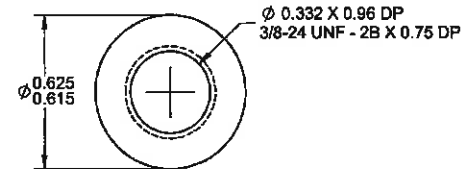
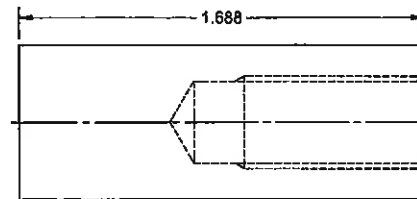
RELEASED
2020 FEB 18 MD

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5805	SHEET 5 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	ATTACHMENT HOOP	NTS
DATE	20.01.13	<small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. </small>	



D5805-7 STUD
(DERIVED FROM AERO DESIGN P/N 76423-05)



D5805-9 STUD
(DERIVED FROM AERO DESIGN P/N 76423-06)

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

- NOTES:**
- 1) MATERIAL: AISI 1018/1025 STEEL ROUND BAR
PER MIL-S-7097 OR ASTM A108
REF DART SPEC M1018-R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -7: 0.09 lbs
-9: 0.12 lbs

RELEASED
2020 FEB 18 NO

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5805 TITLE ATTACHMENT HOOP <small>COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. A
DRAWN	ZF		SHEET 8 OF 8
CHECKED	KPT		SCALE
MFG. APPR.	DD		NTS
APPROVED	NO		
DE APPR.	CP		
DATE	20.01.13		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					